

Work Order ID 62884

Page 1

Tuesday, October 12, 2010 1:07:04 PM

Item ID: D3584-1

Accept



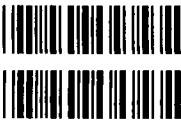
Setup Start



Revision ID:

Item Name: Web

Stop



Start Date: 10/12/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: *P*

Date: 10/10/10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D3584	Rev A	

100 Skidtubes 0.00



Skidtubes

Memo

0.00

3

B/10/10/10

Skidtubes 1-Cut to Length as per Dwg D3584
2-Drill Pillot Holes using DT8960 Drill Jig
3-Open pilloots to 1.000" as per Dwg D3584
4-Deburr

110 QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

10-10-10 (3)

120 Chemical Conversion Coat per QSI005 4.1 0.00



HandFinish Memo 0.00

Hand Finishing

Y3 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62884

Page 2

Tuesday, October 12, 2010 1:07:04 PM

Item ID: D3584-1

Accept



Setup Start



Revision ID:

Item Name: Web

Stop



Start Date: 10/12/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10-10-20

140



Packaging

Packaging

Identify as per dwg & Stock Location: 46. 0.00

Memo

0.00

3 _____ 3B10/20

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/21

MF
10-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, October 12, 2010 1:07:09 PM

Page 1

Work Order ID: 62884



Parent Item: D3584-1



Parent Item Name: Web

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A New Issue 07.06.12 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2963-125 		Manufactured	No			110	Each	122.0000 	1	3			

105 I Beam Extrusion

Location	Loc Qty	Loc Code
HALL	122	
27775	4	
28673	118	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

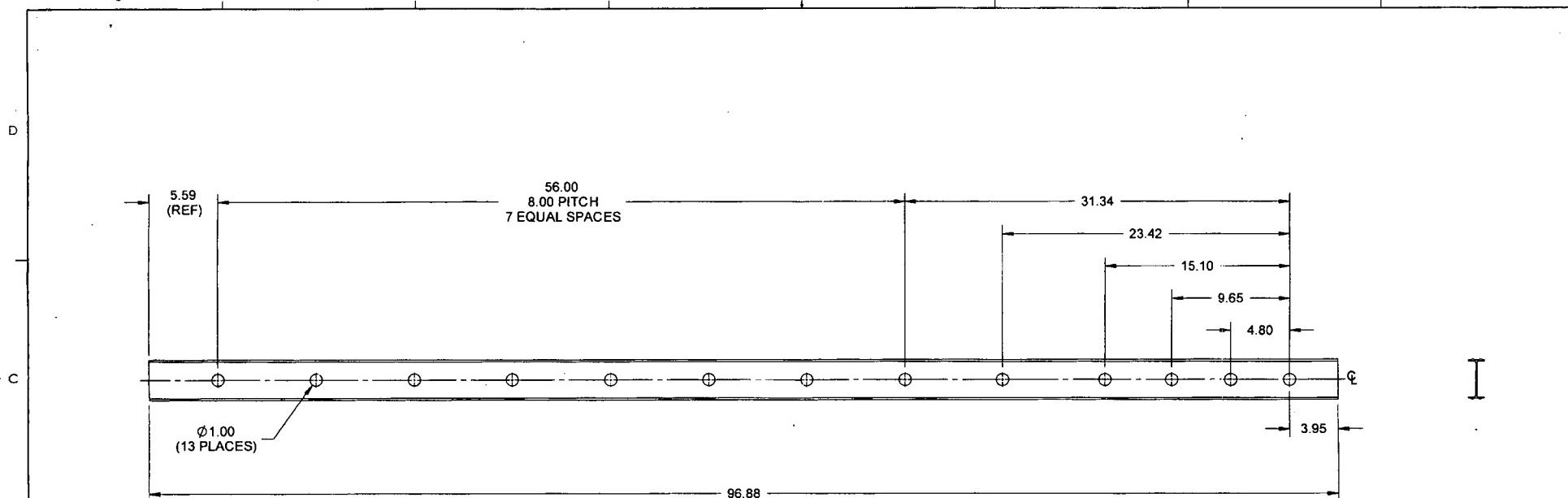
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D3584-1 WEB

SHOP COPY

RELEASER

FNC-AUTOCAD

UNCONTRIBUTED COPY
SUBJECT TO APPROVAL

WITHDRAWN

WORKS CANTER

NO. *62889**B1010-a*RELEASED
07-11-22 JP

- NOTES:
- 1) MATERIAL: MAKE FROM D2963-125 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 TO 0.020
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 5.08 lbs

A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>24</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>24</i>	PORT HADLOCK, WA	
CHECKED	<i>LP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>LP</i>	D3584	SHEET 1 OF 1
APPROVED	<i>JW</i>	TITLE	SCALE
DE APPR.	<i>JW</i>	WEB	1:8
DATE	07.06.08	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

D

C

B

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries